

Work Order ID 133788

133788

Page 1

Wednesday, June 17, 2015 2:52:44 PM

Item ID: D3886-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lug Assembly
 Start Date: 6/17/2015 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 6/17/2015 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: ML5 Date: JUN 17 2015 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3886	B								

100 0.00
100
 Waterjet 20 0 JM15-6-17
 FLOW CNC Waterjet
 304.100"
 Memo
 FLOW WATER JET
 1-Cut as per Dwg D3886-3
 Dwg Rev: B
 Prog Rev: B
 2-Deburr if necessary

110 0.00
110
 QC 20 0 JM15-6-17
 Quality Control
 Memo

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Lug Assembly

Start Date: 6/17/2015 **Start Qty:** 20.00

20

Cust Item ID:

Required Date: 6/17/2015 **Req'd Qty:** 20.00

20

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC8- Inspect parts - second check

0.00

120

0.00

QC

Memo

Quality Control

9-89
 JUN 18 2015

130	0.00
-----	------

130

0.00

Brake NC

Memo

Brake NC

form as per dwg D3886

DAS
30
9-89

JUN 22 2015

140	QC5- Inspect part completeness to step on W/O	0.00
-----	---	------

140

0.00

QC

Memo

Quality Control

20

JUN 23 2015

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Lug Assembly

Start Date: 6/17/2015 **Start Qty:** 20.00

20

Cust Item ID:

Required Date: 6/17/2015 **Req'd Qty:** 20.00

20

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp
------------	------------	---------------	-------------

150

0.00

150

0.00

Large Fab

Memo

Weld as per Dwg D3886 and QSI 004 use DT9626
A/R SS ROD Batch: 128077

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00

160

0.00

QC

Memo

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

170

0.00

QC

Memo

Quality Control

DAS
9
9-89

Work Order ID 133788

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Item ID: D3886-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
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 Start Date: 6/17/2015 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 6/17/2015 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel M 131545. Memo	0.00 START: 2:00. 0.00 OVEN.T: 400° FINISH: 2:30.				12 12	15-9-10.	9-89	
190 *190* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				(12)			DAS 38 9-89 SEP 11 2015 SEP 02 2015
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: St 328 Memo	0.00 0.00				12	DAS 6 9-89	SEP 11 2015	

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Item ID: D3886-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lug Assembly
Start Date: 6/17/2015 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 6/17/2015 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

MCS SEP 14 2015

Sub 20150614

Picklist Print

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Page 1

Work Order ID: 133788

133788

Parent Item: D3886-041

D3886-041

Parent Item Name: Lug Assembly

Start Date: 6/17/2015

Required Date: 6/17/2015

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S12GA

Purchased

No

100

sf

74.2313

0.1472

3

M304S12GA

304/316 0.100" Sheet

**

Jm 15-6-17

Location

Loc Qty

Loc Code

MAT019

74.2313

m131322

74.2313

131322

D3886-1

Manufactured

No

150

Each

18.0000

1

20

D3886-1

Lug

**

15-07-16

JBL

Location

Loc Qty

Loc Code

WA002

18

131067

8

133168

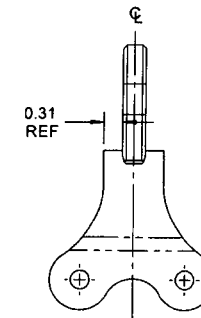
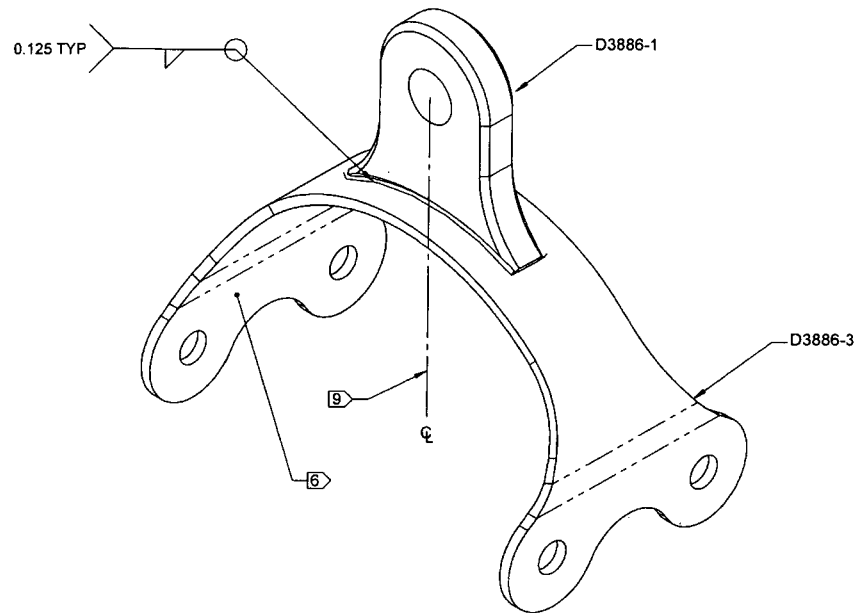
10

18

133790 x12

15-8-9

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3886-041	LUG ASSEMBLY
2	1	D3886-1	LUG
3	1	D3886-3	BRACKET



SHOP COPY
 REF ID: A4-3
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO REVISION
 WITHOUT NOTICE
 WORK ORDER
 NO. 133788 MLC
 1506-12

D3886-041 LUG ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3886-041" AND BATCH NUMBER USING FINE POINT PERMANENT INK MARKER ON UNDERSIDE OF PART
- 7) WEIGHT: 0.53 lbs
- 8) WELD PER DART QSI 004
- 9) BOTH PARTS CENTER SHOULD BE IN LINE WITH THE C

RELEASED
 09/06/03

B	RE-DESIGN D3886-1 (ZN B4-2); RE-DESIGN D3886-3 (ZN A4-3); REVISED D3886-3F (ZN B4-4)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.30		

DART AEROSPACE USA, INC.
 PORT HADLOCK, WA

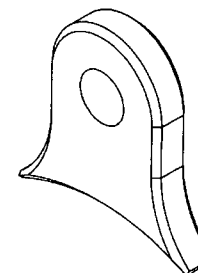
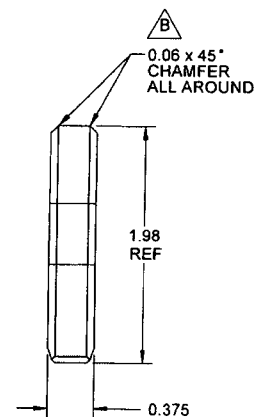
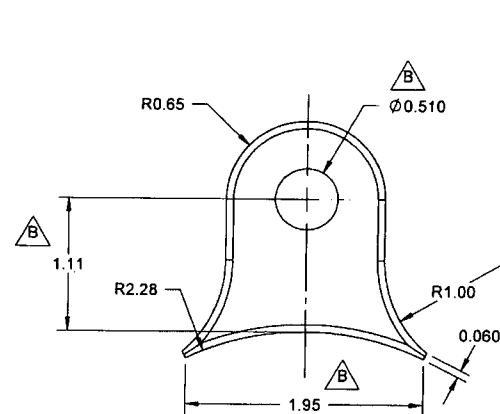
DRAWING NO.
D3886

TITLE
LUG ASSEMBLY

REV. B
 SHEET 1 OF 4

SCALE
 NTS

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D3886-1 LUG 

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR (REF. DART SPEC. M304B0.750X2.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs

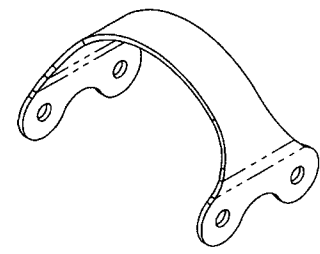
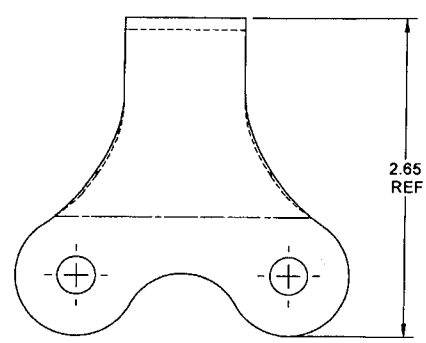
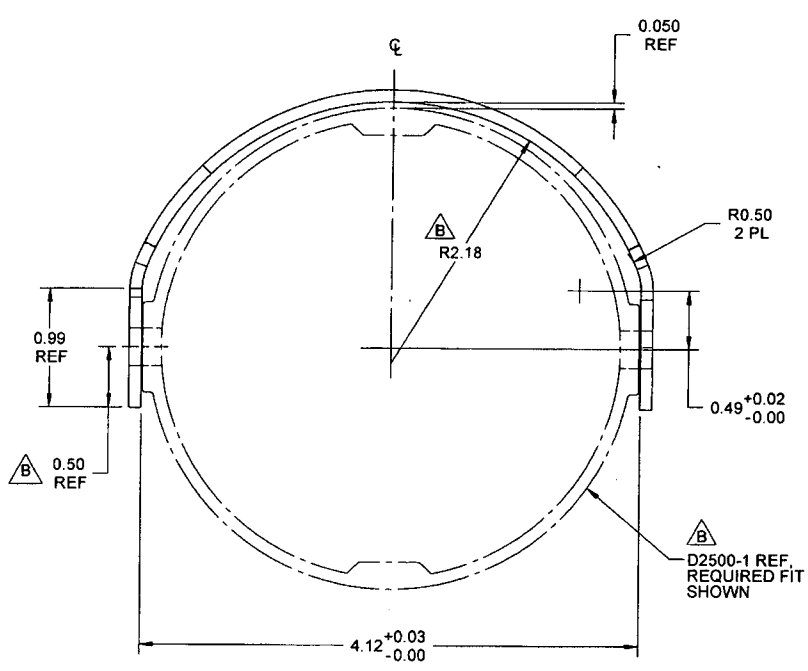
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MFG. APPR.		D3886	SHEET 2 OF 4
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DE APPR.		LUG ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

D
C
B
A

D
C
B
A

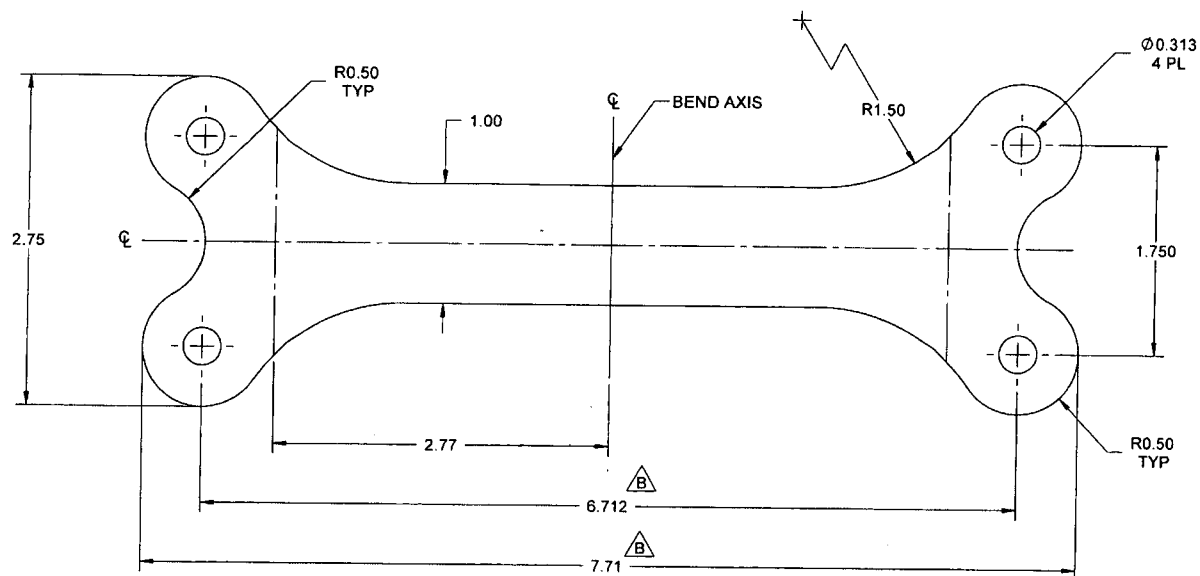


D3886-3 BRACKET $\triangle B$
 (MAKE FROM D3886-3F)

RELEASED
 9/6/15

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3886	SHEET 3 OF 4
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8 7 6 5 4 3 2 1



D3886-3F FLAT PATTERN $\triangle B$

RELEASED
9/6/15

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 12 GAUGE (0.100) THICK, (REF. DART SPEC. M304S12GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.30 lbs

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
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